

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D135-1027 REV. E  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D135-1027 REV. 2  
OR LATER APPROVED REVISIONS

REF. TCCA STC: SH18-49

REF. FAA STC: SR04276NY

REF. EASA STC: 10068097

REF. DGAC MEXICO STC: IA-633/2019

## 1.0 PURPOSE

To ensure compatibility with a variety of step configurations, DART crosstube p/n D135-1027-101/-103/-141/-143/-201/-203/-241/-243 at CHG 003 (or later) and D135-1027-111/-113/-211/-213 at CHG 002 (or later) do not have pre-drilled step attachment holes.

## 2.0 STEP INSTALLATION

It is acceptable to drill step attachment holes in DART D135-1027-XXX crosstubes using the following guidelines (see Figure 1 of this service instruction for reference):

- The drilled holes must be located on the centerline / neutral axis of the crosstube.
- The maximum size for the step holes is 0.625" (15.8mm).
- The drilled holes must be a minimum distance of  $2 \times$  diameter from any existing hole in the crosstube (measured from center of existing hole to edge of drilled hole).
- The holes must be drilled below the midpoint of the crosstube bend.
- Deburr all drilled holes and remove any debris from the inside of the crosstube. Touch up holes with chemical film material (Alodine 1200 or 1201) per MIL-DTL-5541.

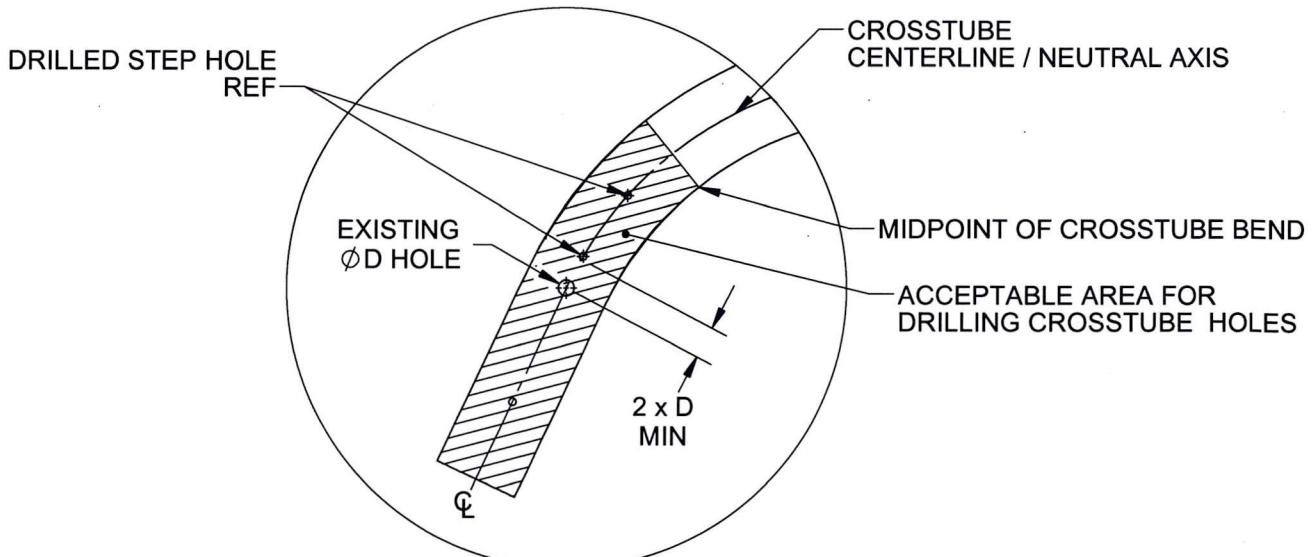


FIGURE 1

TYPICAL DART CROSSTUBE

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

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